

# Work Order ID 52644

October 5, 2009 2:49:48 PM



Page 1

Item ID: D2274

Accept



Setup Start



Revision ID: F

Stop



Item Name: Radius Block

Start Date: 06/10/2009 Start Qty: 500.00



Cust Item ID:

Required Date: 13/10/2009 Req'd Qty: 500.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: *RD*

Date: *09-10-5*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2274

Rev F

100

0.00



SHEAR

Shear

Memo

0.00

*amf 09/10/11*

*500*

Shear

blanks 9.00" long +/- 0.030" □ Note: 1 blank makes 9 pieces

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

*H.A 09/10/11*

*DJP 09/10/13*

*492*

HAAS CNC vertical machine #1

Machine as per folio D2274

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

*H.A 09/10/11*

*DJP 09/10/13*

*492*

Quality Control

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October 5, 2009 2:49:48 PM



Page 2

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

*SP 09/10/13*

*492*



QC

Memo

0.00

Quality Control

140

Small Fab

0.00

*Debur m-h 09/10/14* *(492)* *9-10-20*



Small Fab

Memo

0.00

Small Fab

Tumble ☐ Debur any rough edges after tumbling

150

Chemical Conversion Coat per QSI005 4.1

0.00

*BL 09-10-20*

*(492)*



HandFinish

Memo

0.00

Hand Finishing

**Work Order ID 52644**

October 5, 2009 2:49:48 PM



Page 3

Item ID: D2274  
Revision ID: F  
Item Name: Radius Block

Accept



Setup Start



Stop



Start Date: 06/10/2009 Start Qty: 500.00  
Required Date: 13/10/2009 Req'd Qty: 500.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC3- Inspect Part Finish 0.00



QC

Memo

0.00

Quality Control

\_\_\_\_\_  
Pg 10/21 492

170 Identify as per dwg & Stock Location: \_\_\_\_\_ 0.00



Packaging

Memo

0.00

Packaging

\_\_\_\_\_  
Pg 10/21 492

180 QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

\_\_\_\_\_  
Pg 09.10.27

RL 09-10-22

# Picklist Print

Page 1

October 5, 2009 2:49:48 PM

Work Order ID: 52644



Parent Item: D2274RevF



Parent Item Name: Radius Block

Start Date: 06/10/2009

Required Date: 13/10/2009

Comments:

Start Qty: 500.00

Required Qty: 500.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B00750X00.1 25		Purchased	No			100	f	45.2293	48.2105			



6061-T6 Bar .750 x .125

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

45.2293

104725

7.524

105061

3.4

109760

16.254

110591

18.0593

7.0875

10.2375

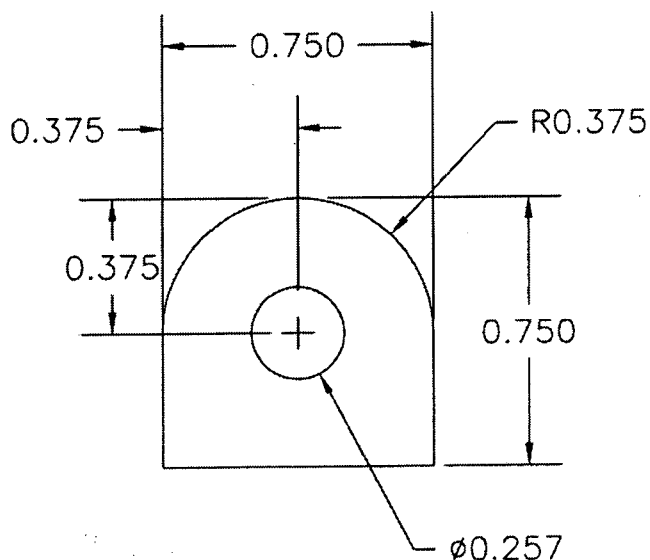
25.9875

*ml 09/00/11*



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11		TITLE RADIUS BLOCK	SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	

RELEASED  
98/08/18 KE



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 52644  
*PL 09-10-5*

*00.05.16*  
*00.05.16*

0.063 x 45° CHAMFER  
R0.0 — 0.13

MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK  
OR 6061-T6 (QQ-A-250/11) 0.125 THICK  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

